

Date: Thursday, 8/23/2007 11:53:20 AM
 User: Kim Johnston

Process Sheet

split w/o
 07/09/19

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ACCESS PANEL ASSEMBLY
 Job Number : 34241 - 2
 Estimate Number : 12949
 P.O. Number : N/A Part Number : D3259042
 This Issue : 8/23/2007 S.O. No. : N/A Drawing Number : D3249 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A1
 Previous Run : N/A Material : N/A
 Written By : Due Date : 9/3/2007 Qty: 4 Um: Each
 Checked & Approved By : 07.08.23
 Comment : Est Rev:A New Issue 07-07-19 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Assembly Kit

2.0 D32591 panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 panel
 Batch: B 34250

SB 07/09/19

3.0 D32594 Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Doubler
 Batch: 20768 ② B34252 ①

SB

4.0 D32595 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Spacer
 Batch: 34253

SB

5.0 D32597 Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Door
 Batch: 20766

SB 07/02/19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/02/19	1	Split w/o 1 piece was made for mesh balance 3	SB	07/02/19	3			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 12 Date: 07/04/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:53:20 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 34241

Part Number: D3259042

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D31615

Hinge 9.9"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Hinge 9.9"

Batch: B 33671

SB 07/09/19

7.0

D32601

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spring

Batch: B 33478

SB

8.0

127H5

HALF GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

HALF GROMMET

Batch: M 15058

SB

9.0

250018C3Y

RIGHT RECEPTACLE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

RIGHT RECEPTACLE

Batch: M 100034

SB

10.0

2501W20020C3Y

STUD



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

STUD

Batch: M 15131

SB

11.0

MS20426AD44

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Rivet

Batch: M 1021

SB

12.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 36.0000 Each(s)/Unit Total: 144.0000 Each(s)

Rivet, Universal Head

Batch: M 15541

SB 07/09/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:53:20 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 34241

Part Number: D3259042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS20470AD35

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Rivet

Batch: M 9682

83 07/09/19

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3259-041 as per Dwg D3259 .
Note: Keep .040" Gap all around door.

m 07/11/08

(X3)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2 07/11/08 (X3)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: ST 182

AS 07/11/09

AS

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2 07/11/09

(3)

Job Completion



11 07/11/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

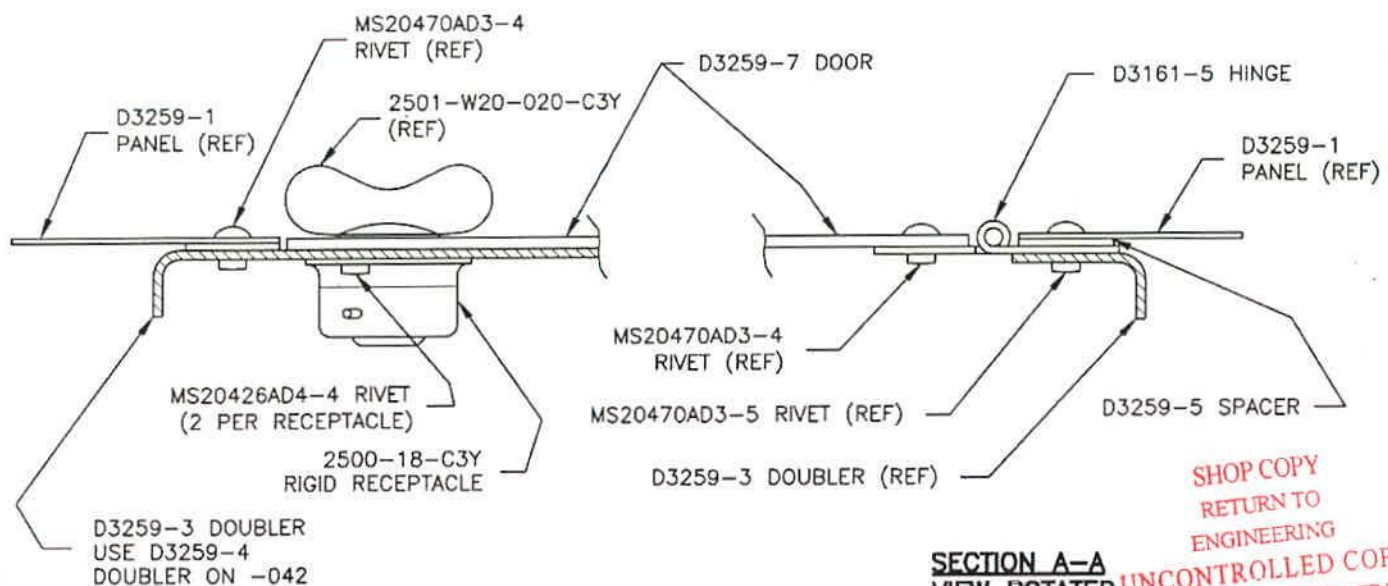
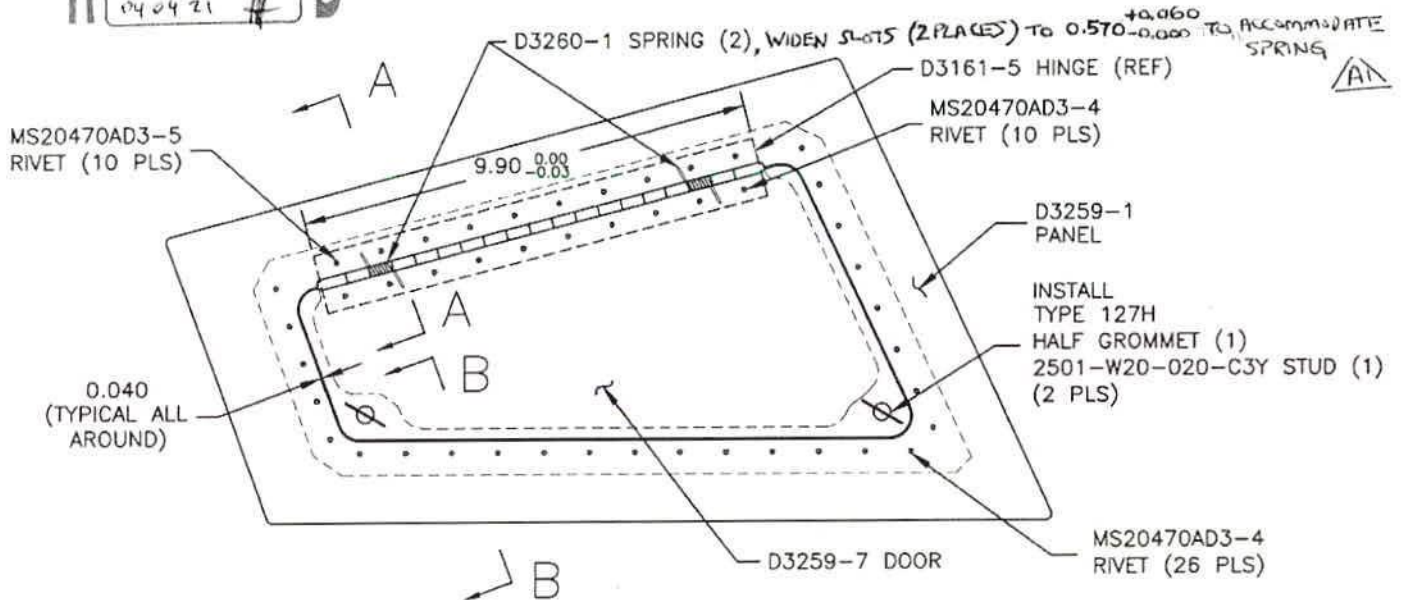
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	RF	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3259
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	REV. A SHEET 1 OF 6
A	04.02.25	NEW ISSUE		SCALE 1:4
AI	CP	04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING	

RELEASED
040421



SECTION B-B
VIEW ROTATED

SECTION A-A
VIEW ROTATED

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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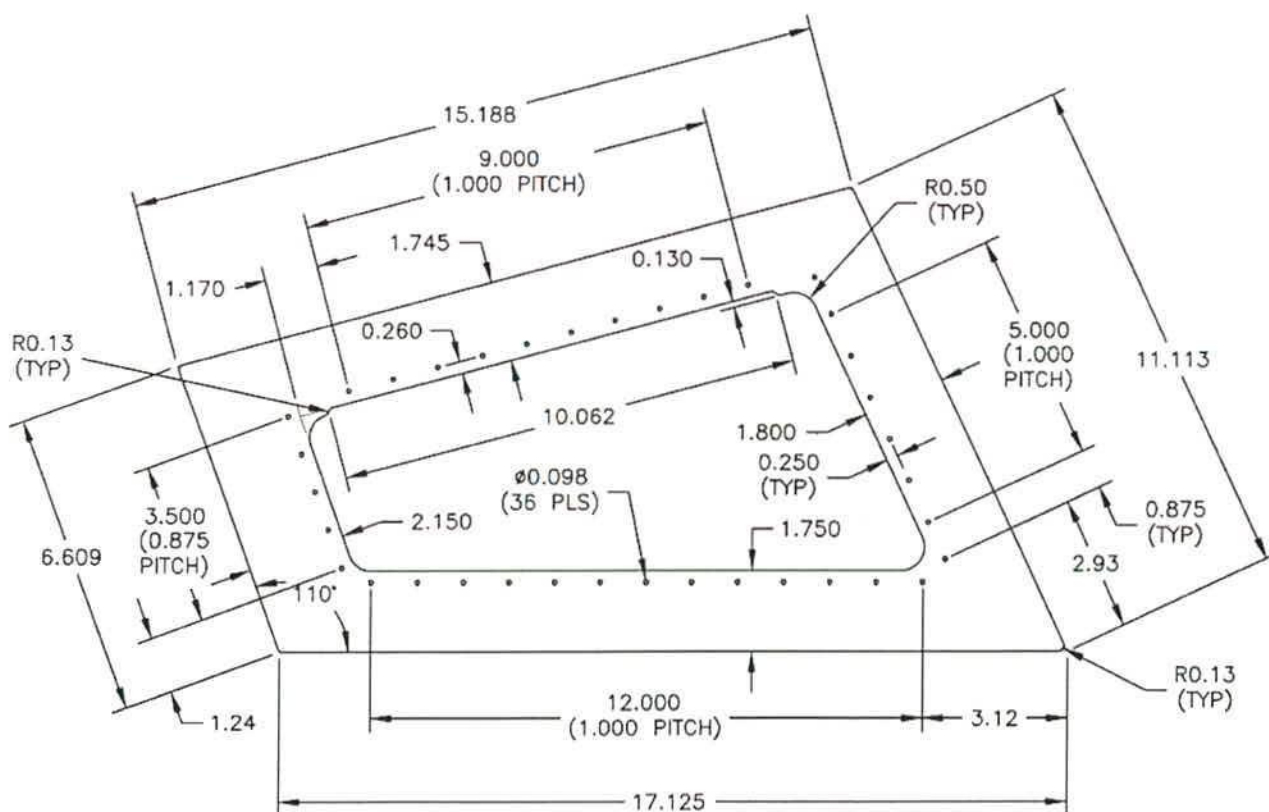
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.05



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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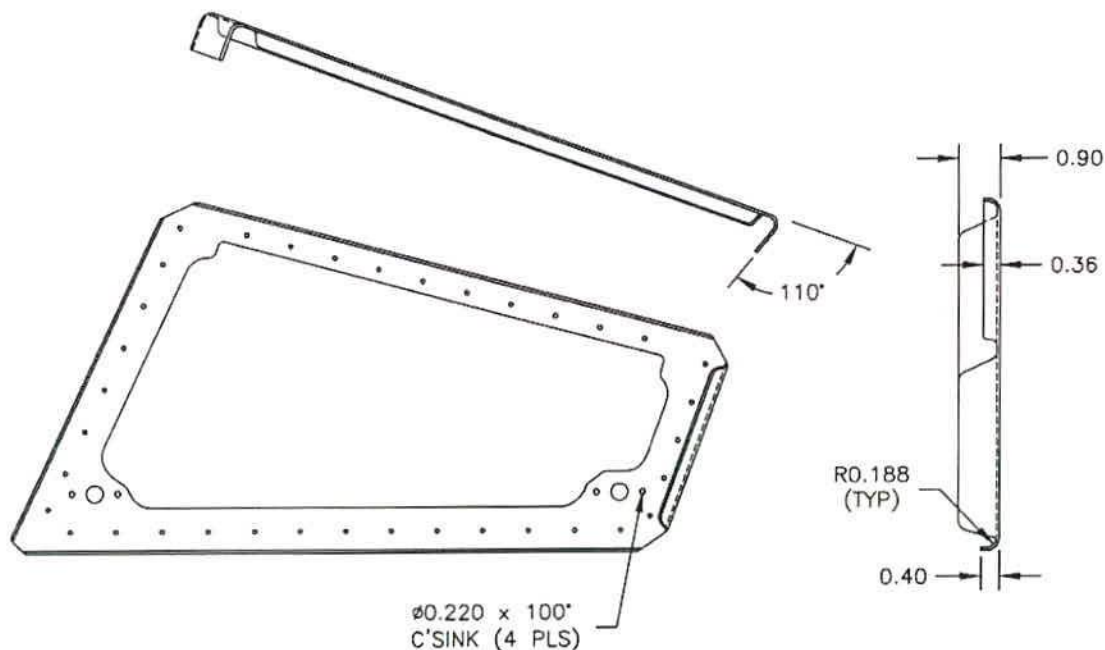
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14



D3259-3 DOUBLER BEND DETAIL (SHOWN)
BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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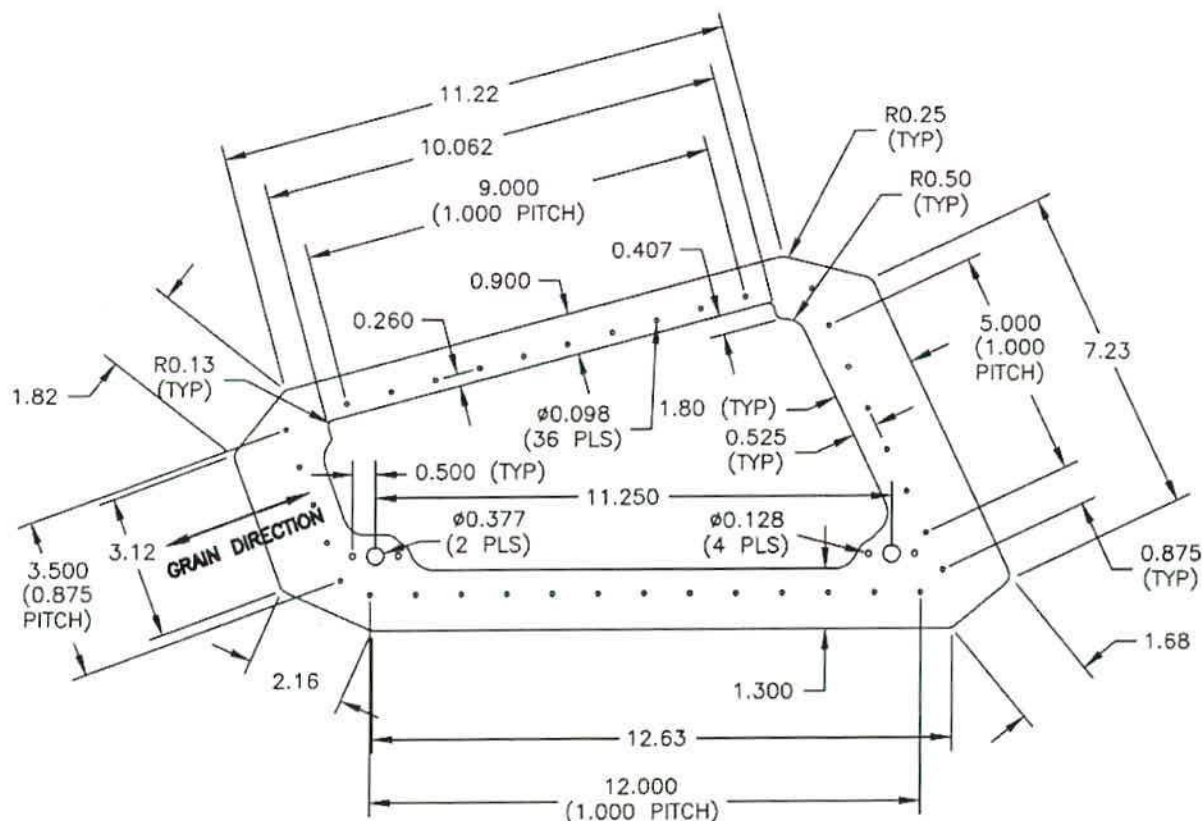
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04 04 14 [Signature]



D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

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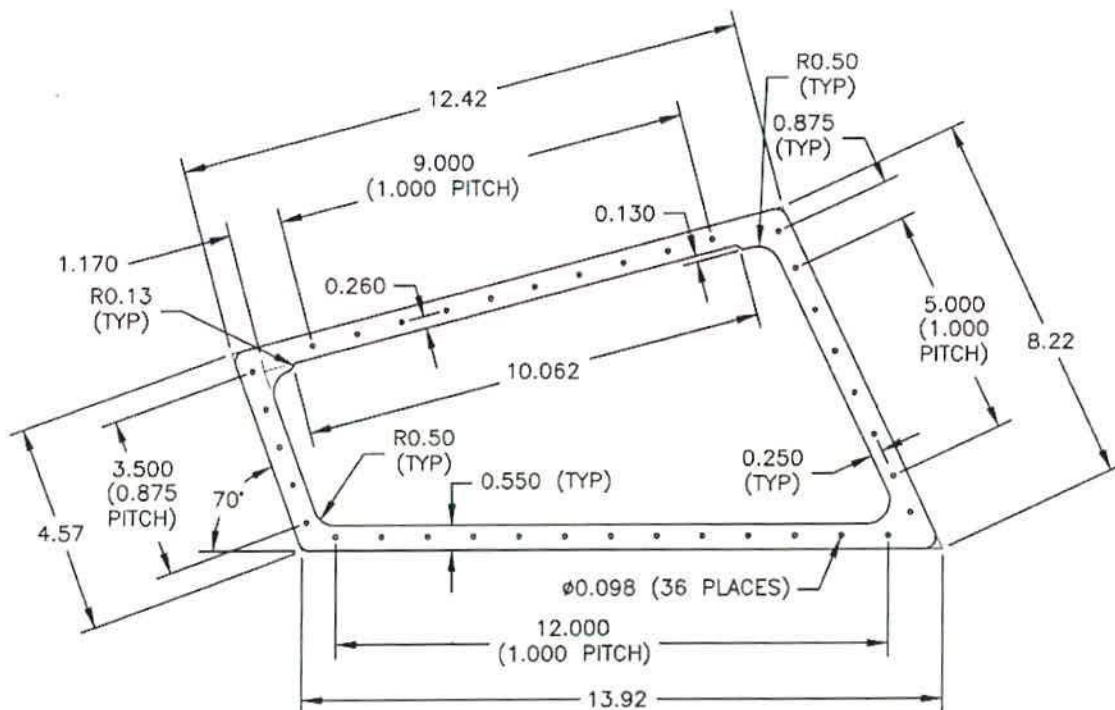
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04-04-05



D3259-5 SPACER

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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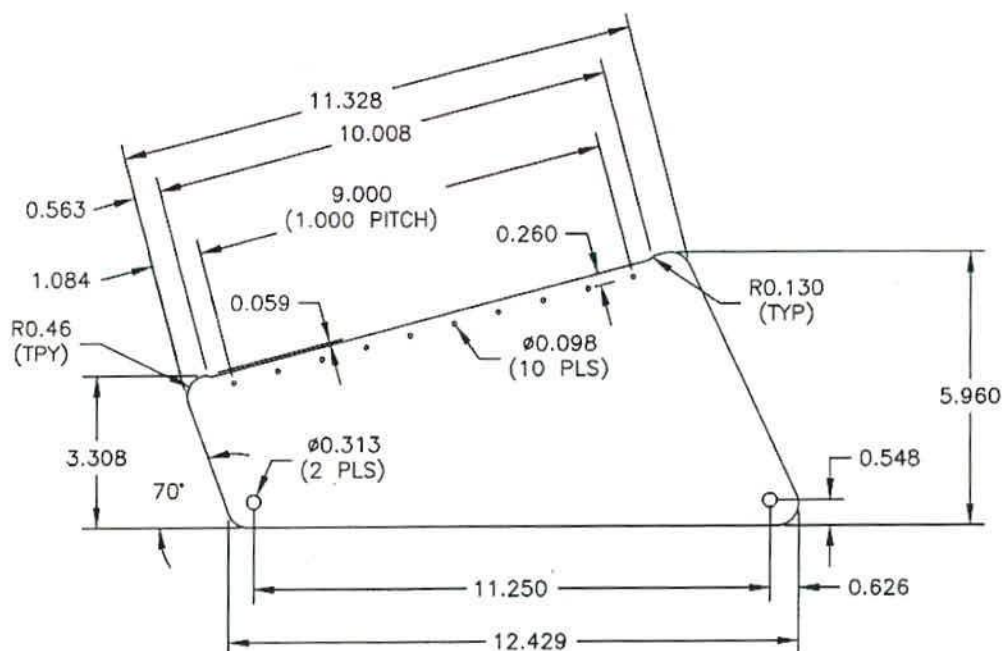
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14 *[Signature]*



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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